Date: User: Wednesday, 6/14/2006 1:45:08 PM

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

: 27544

Job Number Estimate Number : 10310

P.O. Number

:NIA

This Issue Prsht Rev.

: 6/14/2006

: NC

: N/A : 24942

S.O. No. : N/A

SKR (amment Below

: MACHINED PARTS

Project Number

Part Number

Drawing Name

Drawing Revision Material

Drawing Number

Due Date

: D26175

: BUSHING

: D2617 REV D2

: N/A : D2

: NIA

: 6/16/2006

Qty: 30 Um: Each

Checked & Approved By

Comment

First Issue

Written By

Previous Run

: Est H 04.07.14

Reformat; added step 5 KJ/JLM

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:

6061-T6 Tube .500 x.058W

Comment: Qty.: Total: 0.6143 f(s) 0.0205 f(s)/Unit

6061-T6 Round Bar 1.5"

Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6)

Ø0.500" tubing x 0.058" wall M6061T6T0,500W.058 Batch

HARDINGE 2.0

HARDINGE CNC LATHE SMAL

Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA438 and Dwg D2617

2-Deburr

INSPECT PARTS AS THEY COME OFF MACHIN

86/06/14

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

Comment: SECOND CHECK

30

SECOND CHECK

30

5.0

3.0

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROC	EDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No		PAR #:	Fault Category:	NCR: Yes	No) DQ	A.S.	Data: A	6/06/16			

QA: N/C Closed: ____ Date: ____

	,	WORK ORD	ER NON-CONFORMANO	ORMANCE (NCR)						
	Description of NC		Corrective Action Section B	Verification	Annous					
STEP	Section A Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	Approval QC Inspector				
	,									
	·									
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Chief Eng Action Description Chief Eng Section C Section C	STEP Description of NC Section A Initial Chief Eng Chi			

NOTE: Date & initial all entries

Date: Wednesday, 6/14/2006 1:45:08 PM User: Linda Lacelle **Process Sheet Drawing Name: BUSHING** Customer: CU-DAR001 Dart Helicopters Services Job Number: 27544 Part Number: D26175 Job Number: Seq. #: **Machine Or Operation:** Description: INSPECT POWDER COAT/CHEMICAL CONVERSION QC3 6.0 **Comment: INSPECT ALODINE** PACKAGING RESOURCE #1 7.0 PACKAGING 1 **Comment: PACKAGING RESOURCE #1** Identify and Stock Location: 5 \ 53 8.0 DC DOCUMENT CONTROL 1 No. de. 15 Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Ae	rospace	Ltd								
W/O:			WC	RK ORDER CH	ANGES					
DATE	STEP	PR	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Categ	jory:	NCI	R: Yes ↑	No DQ	A:	_ Date: _	
						QA: N/	C Close	d:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFO	RMANCE	(NCR)				
DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign &		cation	Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Sect	on C	Chief Eng	QC Inspector
					·					
		•								

NOTE: Date & initial all entries



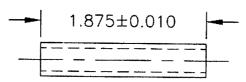


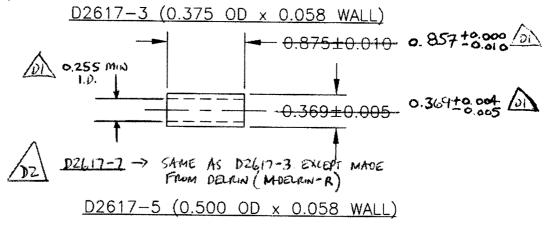
	DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		felegy
	CHEC	KED #	APPROVED	DRAWING NO. D2617 SHEET	REV.	_
	DATE			TITLE	SCA	LE
_	01.0	7.04		BUSHING	1	1:1
	Α		96.10.08	NEW ISSUE		
	_					

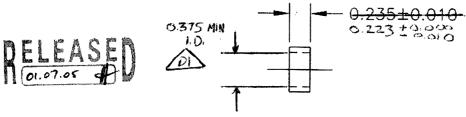
DZ 04.04.10 #11 ADD D2617-7

97.05.08 | .875 WAS 1.125 C 97.06.04 0.369 DIA WAS 0.375 01.07.04 ADD MAT'L SPEC AND TOL./DIM. NOTE 04.07.12 CORRECT TOLERANCE (NCR 779)

OD 0.058 WALL)







NOTES:

1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)

OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE STEP			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		*									
							·				
5 4 N											

Part No:	PAR #:	Fault Category:	NCR: Yes	No	DQA:	Date:	
			QA: N	/C CI	osed:	Date:	

NCR:			CE (NCR)					
		Description of NC		Corrective Action Section B				A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
•								
						ł (1	

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:		
Description: Bushing		Part Number:	D2617-5	
Inspection Dwg: D2617 Rev	r: D2		Page 1 of 1	_

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.223	+0.000/-0.010	1221				
0.500	+0.005/-0.000	1502				
,375	+,006	,221 ,502 ,377				

Measured by:	All)	Audited by: 5	Prototype Approval:	N/A
Date:	06/06/14	Date: 06/66/14	Date:	N/A

R	lev	Date	Change	Revised by	Approved
	A	04.08.09	New Issue	KJ/JLM	
	В	06.03.08	Dwg Rev change	KJ/JLM	·